

SI 308L

Submerged Arc Welding Wire - Stainless Steels

Standards

AWS/ASME SFA - 5.9	ER308L
EN ISO 14343 - A	S 19 9 L
TS EN ISO 14343 - A	S 19 9 L
DIN M. No.	1.4316

Properties and Applications

Austenitic stainless steel welding wire for submerged arc welding of unstabilized or stabilized corrosion resisting Cr-Ni steels tanks, pipes and equipments, used in food, beverage and pharmaceutical industries. Used in combination with SIF 501 and SIF 502 submerged arc welding fluxes. Weld metal is resistant to intergranular corrosion up to 350°C. Non-scaling up to 800°C, in air or oxidizing combustion gases.

Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni
Welding Wire	0.02	0.40	1.80	20.00	9.50

Typical Chemical Values of Weld Metal


Welding Flux	Type of Analysis	C	Si	Mn	Cr	Ni
SIF 502	Weld Deposit	0.02	0.65	1.00	20.00	9.50
SIF 501	Weld Deposit	0.02	0.35	1.60	18.00	9.00


Typical Mechanical Values of Weld Metal

Test Condition	Welding Flux	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)		
As welded	SIF 502	390	565	36	20°C → 80	-60°C → 60	-195°C → 45
As welded	SIF 501	380	530	38	20°C → 90	-60°C → 70	-196°C → 50

Application Information

Welding Positions


PA


PB

Polarity:

= +

Welding Parameters & Efficiency

	Diameter (mm)
	2.40
	3.20

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
43001XAM2	2.40	25 kg	25.90	1	25.90	Wire Basket Spool (K435)
43001LXAM2	3.20	25 kg	25.90	1	25.90	Wire Basket Spool (K435)

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.